Application Data Sheet

SCHNEEBERGER

Knee Femoral

A26-300

Based on 3D-Models, the wheelpaths can automatically be generated through a meshintersector programm. Individually definitions as the distance from one section to another along the complete path as well as the included angle over the 3D model are possible. According to the momentaneous normal on the surface the corresponding grinding point on the radius wheel is automatically adopted by moving along the radius or combined by inclining the wheel.

1. Cycletime for production

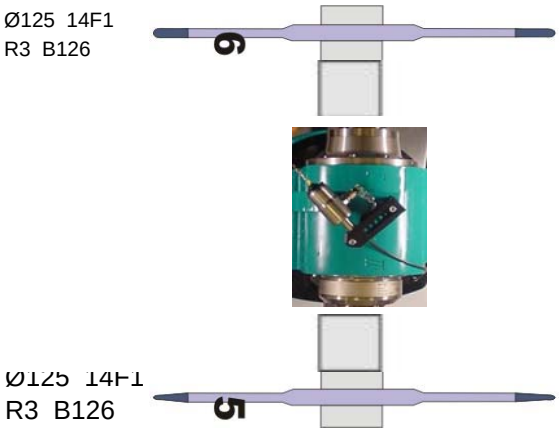
Toolspecifications

Preshaped casting part

Operations	 Profile Pregrind	 Profile Finish
Feed [mm/Min]	150	200
Power [kW]	1	1
Cutting feed [m/s]	32	32
Used wheels	 5	 6
Grinding time [s]	1203	4802
Total cycle time	100 Min 5	

The mentioned cycle times are indicative. The material to be ground, other grinding wheels and other coolants can influence the cycle times considerably.

2. Used grinding wheels



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR
Control: Fanuc 31i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 5
responsable engineer: S. Sigrist, 19.1.07

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TECHNOLOGY FOR TOOLING